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Indian Standard

SPECIFICATION FOR SINGLE WALLED BAKING OVENS

UDC 64·06-83 : 621·365 : 643·33

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INDIAN STANDARDS INSTITUTION
MANAK BHAVAN, 9 BAHADUR SHAH ZAFAR MARG
NEW DELHI 110002

March 1979

AMENDMENT NO. 1 MAY 1989
TO
IS : 8985 - 1978 SPECIFICATION FOR SINGLE WALLED BAKING OVENS

(*Page* 12, *clause* **9.3.5**) — Substitute the following for the existing clause:

'**9.3.5** *Endurance Test* — The oven is operated at the maximum setting of the thermostat, if provided. It is operated such that the input is 1·15 times the maximum rated input. Under these conditions, the oven is operated for 96 operating hours.

At the end of this test, the oven shall comply with the requirements of **52.7** of IS : 302-1973.'

(ETDC 43)

Printed at Printwell Printers, Delhi, India

Indian Standard

SPECIFICATION FOR SINGLE WALLED BAKING OVENS

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(*Continued on page* 2)

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Indian Standard

SPECIFICATION FOR SINGLE WALLED BAKING OVENS

0. FOREWORD

0.1 This Indian Standard was adopted by the Indian Standards Institution on 10 November 1978, after the draft finalized by the Electrical Appliances Sectional Committee had been approved by the Electrotechnical Division Council.

0.2 This standard covers general and safety requirements along with performance requirements of single walled baking ovens. The necessity of performing some actual baking tests is also recognized and Appendix A gives a few of such tests for general guidance.

0.3 Reference has been made in this standard to IS : 302-1973* with regard to general and safety requirements as well as methods of test which is necessary adjunct to this standard. Should, however, any deviation exist between the requirements of IS : 302-1973* and those of this standard, provisions of the latter shall apply.

0.4 For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated, expressing the result of a test, shall be rounded off in accordance with IS : 2-1960†. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

1. SCOPE

1.1 This standard lays down the performance, general and safety requirements and methods of test for single walled baking ovens for baking and grilling designed for household use. These ovens are to be designed for connection to supplies at voltage not exceeding 250 V ac single-phase 50 Hz and/or dc with power input up to 20 kW.

1.2 This standard does not cover double walled cooking ovens which are covered by IS : 5790-1970‡.

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*General and safety requirements for household and similar electrical appliances (*fourth revision*).

†Rules for rounding off numerical values (*revised*).

‡Specification for domestic electric cooking ovens.

2. TERMINOLOGY

2.1 For the purpose of this standard, the following definitions in addition to those specified in IS : 302-1973* shall apply.

2.1.1 *Baking Pan* — A sheet or tray which can be withdrawn and on which food items, such as cake, biscuits can be baked.

2.1.2 *Conditions of Adequate Heat Discharge* — The load that apply when a heating appliance is operated under normal conditions of use. Baking ovens and other similar appliances for baking and grilling are operated so that the temperature at centre of heater surface is maintained at 250 ± 15°C, either by means of a thermostat or by switching the supply 'on' and 'off'. If the thermostat does not allow temperature to reach 250°C, the appliance is operated with the thermostat at the highest setting.

2.1.3 *Oven* — A chamber which can be closed, and incorporates heating units intended for heating the chamber, in which baking and/or grilling is carried out.

2.1.4 *Automatic Oven* — An oven which is thermostatically controlled.

2.1.5 *Non-automatic Oven* — An oven which is not thermostatically controlled. It may however be provided with a thermal cut-out.

2.1.6 *Temperature of Oven* — The temperature anywhere in the central position of baking space, the space being the cube of 5 cm around the geometric centre of oven.

2.1.7 *Baking Space* — The space within an oven which is above the lowest position of baking oven and not less than 5 cm from heating surface.

2.1.8 *Oven Grill* — An oven which is provided with a grilling arrangement with a heating element fixed near the top of the baking space.

3. RATING

3.1 Voltage Rating — The provision of **3.1.2** and **3.1.3** of IS : 302-1973* shall apply.

3.2 Rated Input — The provisions of **3.2** of IS : 302-1973* shall apply. However, the rated input shall not exceed 2·0 kW.

4. MATERIALS

4.1 The provisions of **7.11** and **7.12** of IS : 302-1973* shall apply.

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*General and safety requirements for household and similar electrical appliances (*fourth revision*).

5. CONSTRUCTION

5.1 The requirements specified in **5.2** to **5.7** in addition to the relevant provisions of **7** of IS : 302-1973* shall apply.

5.2 Heating Chamber

5.2.1 The interior of the oven lining, sheet metal oven runners and baffles, drip-trays, and the inner panel of the oven door when made out of mild steel, shall be finished in vitreous enamel having resistance to thermal shock and heat such that it shall comply with the requirements laid down in IS : 3972-1968†. These may also be made of commercial purity aluminium (*see* IS : 737-1974‡) in half hard condition duly-anodized or stainless steel or any other suitable material or finish.

5.2.2 The heating chamber shall be so constructed and reinforced that baking pan is adequately supported, and the material of heating chamber does not warp buckle when heated to maximum temperature of oven.

5.2.3 Interior surfaces of the baking oven should be such that they lend themselves for early and thorough cleaning even after continuous use.

5.2.4 The ovens shall be provided with a suitable viewing arrangement.

5.3 Vents — One or more suitable vents shall be provided near top of oven, so arranged that they deflect fumes and moisture away.

5.4 Baking Pan and Tray — Every oven shall be supplied with at least one baking pan and one tray. The baking pan and tray shall be made of aluminium or any other suitable material taking into consideration that it does not warp on heating.

5.5 Heating Element — The heating element shall be so designed and located that the heating condition required for baking can be obtained and local over-heating or burning of the food stuffs avoided. Use of mineral filled sheathed heating elements conforming to IS : 4159-1976§ is recommended. However, if bare heating coils supported in a tubing is used, steatite ceramic shall be used for supporting the heating coil.

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*General and safety requirements for household and similar electrical appliances (*fourth revision*).

†Methods of test for vitreous enamelware.

‡Specification for wrought aluminium and aluminium alloys, sheet and strip (for general engineering purposes) (*second revision*).

§Specification for mineral filled sheathed heating elements (*first revision*).

5.6 Wiring and Components — The wiring and all the components used in an oven shall be constructed and fixed in such a manner that they shall be able to withstand continuously the temperature to which they are exposed when the oven is operated at its maximum temperature. All the wiring and components shall be suitably protected from spillage or overflow from vessels in the oven.

5.7 Thermostats — Where a thermostat is used it shall comply with **49** of IS : 302-1973*. An indicator shall be provided to give an indication when the contacts of thermostat have a voltage and current rating not less than the heating element it controls.

5.8 Handles — The oven shall be provided with handles of adequate size so that possibility of touching the body while handling the oven is avoided. The handles shall be made of heat insulating material for safe handling of the oven.

5.9 Switches — Manually operated switches if used in an oven shall comply with the relevant provisions of IS : 3854-1966†. Switches and controls shall be located or protected so that they are not subjected to mechanical injury, spillage from baking or collection of grease.

5.10 Heat Control — Oven heating elements of 750 watts and over shall be controlled by a switch having not less than three heat steps, by an energy regulator, or by a thermostat. A non-automatic oven shall be provided with a temperature indicator. In case of grill type of ovens provisions for separate switching arrangement of the grilling element shall be provided.

6. GENERAL AND SAFETY REQUIREMENTS

6.1 Protection Against Electric Shock — The provisions of **8** of IS : 302-1973* shall apply.

6.2 Input — The provisions of **9** of IS : 302-1973* shall apply.

6.3 Temperature-Rise — The provisions of **10.1** of IS : 302-1973* shall apply except that the temperature-rise for thermostat knob shall not exceed 55°C.

6.4 Electrical Insulation — The provision of **11** of IS : 302-1973* shall apply.

6.5 Stability — The provisions of **14.2** of IS : 302-1973* shall apply.

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*General and safety requirements for household and similar electrical appliances (*fourth revision*).

†Specification for switches for domestic and similar purposes.

6.6 Mechanical Strength — The provisions of **15** of IS : 302-1973* shall apply.

6.7 Supply Connections — The provisions of **20** of IS : 302-1973* shall apply.

6.8 Terminals — The provisions of **21** of IS : 302-1973* shall apply.

6.9 Earthing — The provisions of **22** of IS : 302-1973* shall apply.

6.10 Endurance — The provision of **19.1** of IS : 302-1973* shall apply.

6.11 Abnormal Operation — The provision of **16.1** of IS : 302-1973* shall apply.

6.12 Creepage Distances and Clearances — The provisions of **24.1** of IS : 302-1973* shall apply.

6.13 Screws and Connections — The provisions of **23** of IS : 302-1973* shall apply.

6.14 Resistance to Rusting — The provisions of **7.33** of IS : 302-1973* shall apply.

7. PERFORMANCE REQUIREMENTS

7.1 Heating Up Time — The heating up time for an oven when determined in accordance with **9.3.2** shall not exceed 15 minutes.

7.2 Uniformity of Temperature — When tested in accordance with **9.3.3**, the temperature within the oven in same horizontal plane shall be uniform.

7.3 Thermostat Setting — When tested in accordance with **9.3.4,** the oven temperature shall not differ from the thermostat-setting by more than 15°C where a thermostat is provided.

7.4 Temperature Differential — When tested in accordance with **9.3.4,** the temperature differential of automatic oven shall not exceed 15°C.

8. MARKING AND INSTRUCTIONS FOR USE

8.1 Every oven shall be marked indelibly and clearly in accordance with **25** of IS : 302-1973* on its outer surface or on a name plate firmly attached to it. A clear marking indicating the different switch positions and corresponding rating in watts shall be provided where multi-step switches are provided. In addition to above, a marking stating whether the oven is insulated 'OR' uninsulated type shall be there.

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*General and safety requirements for household and similar electrical appliances (*fourth revision*).

8.2 Earth Terminals — The symbol '⏚' shall be marked prominently on or adjacent to the earth terminals, if provided.

8.3 The ovens may also be marked with the ISI Certification Mark.

> NOTE — The use of the ISI Certification Mark is governed by the provisions of the Indian Standards Institution (Certification Marks) Act and the Rules and Regulations made thereunder. The ISI mark on products covered by an Indian Standard conveys the assurance that they have been produced to comply with the requirements of that standard under a well-defined system of inspection, testing and quality control which is devised and supervised by ISI and operated by the producer. ISI marked products are also continuously checked by ISI for conformity to that standard as a further safeguard. Details of conditions under which a licence for the use of the ISI Certification Mark may be granted to manufacturers or processors, may be obtained from the Indian Standards Institution.

8.4 Instructions for Care and Use — Every oven shall be supplied with the necessary instructions booklet including precautions to be taken for its proper use. The instruction shall describe in detail the manner of carrying out the various baking operations which are possible with the oven and shall in particular indicate the best position in the oven for different types of baking, type of vessel to be used, cleaning instruction and the appropriate thermostat setting for various baking operation where a thermostat is provided.

9. TESTS

9.1 Categories of Tests

9.1.1 *Type Tests* — The tests specified in Table l shall constitute type tests and shall be carried out on two samples of ovens of the same make type and rating (selected preferably at random from a regular production lot). The tests shall be carried out in order specified unless otherwise agreed to.

9.1.1.1 *Criteria of acceptance* — Both the samples shall successfully pass all the type tests for providing conformity, with the requirements of this standard. If any of the samples fails in any of the type tests, the testing authority at its discretion, may call for fresh samples not exceeding twice the original number and subject them again to all the tests or to the test(s) in which failure(s) occurred. No failure shall be permitted in the repeat test(s).

9.1.2 *Acceptance Tests* — The following shall constitute the acceptance tests:

Tests	*Clause Reference*	
a) Visual examination and inspection	9.3.1	
b) Protection against electric shock	40	of IS : 302-1973*
c) High voltage test	42.3	
d) Insulation resistance (dry)	11.1.3 and 44.3	
e) Leakage current	42.1 to 42.2	
f) Earthing connection	38	
g) Input	45	
h) Uniformity of temperature	9.3.3	
j) Temperature-rise	41 of IS : 302-1973*	

9.1.2.1 A recommended sampling procedure of acceptance tests is given in Appendix C of IS : 302-1973*.

9.1.3 *Routine Tests* — The following shall constitute the routine tests:

Test	*Clause Reference*	
a) Visual examination and inspection	9.3.1	
b) Protection against electric shock	40	of IS : 302-1973*
c) High voltage	42.3	
d) Insulation resistance (dry)	11.1.3 and 44.3	
e) Earthing connection	38	

NOTE 1 — High voltage test as a routine test may comprisc the flash test as specified in **42.3.3** of IS : 302-1973*.

NOTE 2 — Insulation resistance test as a routine test may be done in accordance with **44.3** of IS : 302-1973* but without conditioning. The values shall conform to **11.1.3** of IS : 302-1973*.

9.2 General Conditions of Test

9.2.1 The relevant provisions of **26** of IS : 302-1973* shall apply.

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*General and safety requirements for household and similar electrical appliances (*fourth revision*).

TABLE 1 SCHEDULE OF TYPE TESTS

(*Clauses* 9.1.1 *and* 9.3)

SL No.	TEST	METHOD OF TEST, REF TO	
		Cl No. in This Standard	Cl No. in IS : 302-1973*
(1)	(2)	(3)	(4)
i)	Visual examination and inspection	9.3.1	—
ii)	Stability	—	32.2
iii)	High voltage	—	42.3
iv)	Insulation resistance (dry)	—	11.1.3 and 44.3
v)	Protection against electric shock	—	40
vi)	Leakage current	—	42.1 and 42.2
vii)	Earthing connection	—	38
viii)	Input	—	45
ix)	Heating up time	9.3.2	—
x)	Uniformity of temperature	9.3.3	—
xi)	Temperature rise	—	41
xii)	Thermostat setting and temperature differential	9.3.4	—
xiii)	Endurance test	9.3.5	—
xiv)	Screws and connections	—	35
xv)	Abnormal operation	—	47
xvi)	Mechanical strength	—	36
xvii)	Resistance to rusting	—	37

*General and safety requirements for household and similar electrical appliances (*fourth revision*).

9.2.2 *Surroundings* — For carrying out the tests specified in **9.3.2** to **9.3.5**, place three plywood screens with dull black painted surfaces at a distance of 25 cm on the back and both sides of the oven, extending from the floor to a height of at least two metres, completely enclosing the oven from three sides with the oven located approximately at the centre of the screen height on a wooden table. Protect the oven and screens from draughts.

9.2.3 *Measurement of Temperature* — The ambient temperature shall be measured with a mercury-in-glass thermometer having a bulb capacity of not over 0·5 ml and an error not over 1°C in the working range. The oven temperature shall be measured with either a similar thermometer, or a thermocouple or thermister located approximately at the centre of the heating chamber, and at least 3 cm away from any rack, sheet or other metallic object.

9.3 Schedule of Tests — The schedule of tests to be carried out on the ovens for proving conformity with the requirements of this standard is given in Table 1 with reference to the relevant clauses of this standard or of IS : 302-1973* wherever applicable.

9.3.1 *Visual Examination and Inspection*

9.3.1.1 The ovens shall be visually examined and inspected for obvious visual defects in respect of components, parts and their assembly, construction, stability, marking, provision of suitable terminals for supply connections, earthing and the effectiveness of screws and connections.

9.3.1.2 The supply connections shall be of size appropriate to the rating (*see* **20** of IS : 302-1973*).

9.3.1.3 The external surface finish shall be even and free from finishing defects.

9.3.2 *Heating-Up Time* — The oven is connected to supply and switched on with the rated power supplied to the elements, and the oven temperature is observed. The time taken by the oven to reach a temperature 180°C above the ambient is taken as the heating-up time. In case of automatic ovens the test shall be conducted at the maximum setting of the thermostat.

9.3.3 *Uniformity of Temperature* — Commercial grade *MAIDA* used for biscuits and cakes shall be obtained. A quantity has to be weighed out and placed in a fine muslin pouch. It shall be carefully sprinkled over the baking sheet provided with the oven so that it covers uniformly over the whole surface.

The oven is operated at 175 ± 5°C and when steady conditions are reached and the thermostat has cycled at least five times, the sheet is placed on baking trays. The sheet is withdrawn after 10 minutes and the contents are examined visually. Uniform browning of the flour is taken to indicate uniform temperature in the horizontal plane tested. If the baking sheet provided with the oven is of aluminium, it is blackened on both sides with suitable cooking medium. The above test is carried out again with the blackened sheet.

9.3.4 *Thermostat Setting and Differential* (*for Automatic Ovens Only*) — The oven temperature is measured within 10 seconds of every cut-in and cut-out of thermostat, after stable conditions have been obtained, with thermostat setting at 95°C. The oven temperature is taken at an average of not less than 3 consecutive sets of observed minimum and

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*General and safety requirements for household and similar electrical appliances (*fourth revision*).

maximum temperatures corresponding to the make and break of the thermostat. The tests are repeated with thermostat setting at 175°C and at 225°C. The maximum difference in temperature observed during any one of the above tests shall be taken as temperature differential of the oven.

9.3.5 *Endurance Test* — The oven shall be operated at rated input and at the maximum setting of the thermostat, if provided, for 300 cycles, each cycle comprising 90 minutes 'on' period and 30 minutes 'off' period. For non-automatic ovens the temperature shall be maintained at 290 ± 5°C. The lid of the oven shall be kept closed except for short durations. After this operation, the thermostat and control knobs shall show no sign of mechanical injury and no change shall be noticeable either in the external appearance or performance of the oven and the various other components of the same. Further, during the above period the lid of the oven shall be opened and closed at least once every hour. During and after the test, no mechanical defects, such as sticking of the lid due to the heat shall be noticeable.

APPENDIX A

(*Clause* 0.2)

OPERATIONAL TESTS FOR GUIDANCE

A-1. GENERAL

A-1.1 The tests described in the following clauses shall be performed by trained cook experienced in evaluating the performance of oven and the results judged on the points indicated by a panel of at least five persons. In case the results obtained are deemed unsatisfactory, it will be open to the manufacturer or supplier to depute his own trained cook to perform the tests under supervision of the testing authority.

A-l.2 The oven shall be preheated at its maximum operating temperature for at least 2 hours before commencing the tests. The temperature recommended in the standard recipes shall be obtained, if necessary, by applying a suitable correction to the thermostat settings, obtained from preliminary experiments with the empty oven. In the case of non-automatic oven an auxiliary thermostat may be used to control the temperature. The recommended temperatures shall be maintained within ± 5°C during the period of tests. As far as possible ingredients of well-known brands or ISI certified ingredients shall be used for the tests. The manufacturer's instructions regarding the switching of elements or placement of dishes shall be followed as long as they do not conflict with the directions given.

A-2. TEST BISCUIT

A-2.1 Recipe —
250 g vanaspati (hydrogenated oil),
200 g sugar,
2 eggs (each weighing 50 to 56 g),
500 g wheat flour (*MAIDA*), and
Vanilla and salt to taste.

The baking sheet is covered at least to 90 percent of its surface. The baking sheet is placed on a rack or support near the centre of the height of the heating chamber of the oven and baked at 225°C till golden yellow. The baking time is noted. The baked biscuits are cooled on a rack and both sides of all the biscuits are examined for uniform development of colour.

A-3. TEST CAKE — TYPE 1

A-3.1 Recipe —
200 g vanaspati,
200 g sugar,
3 eggs (each weighing 50 to 56 g),
500 g wheat flour (*MAIDA*),
150 ml milk,
12 g baking powder, and
salt to taste.

The cake is baked at 175°C in a mould of black steel sheet placed on the lowest runners or supports on the oven liner. The baking time is noted and the interior is examined for uniform and good texture. The crust is examined for uniform colour.

A-4. TEST CAKE – TYPE 2

A-4.1 Recipe —
3 eggs yolks,
3 to 4 spoons hot water,
100 g powdered sugar,
whipped white of 3 eggs,

50 g sugar,
100 g wheat flour (*MAIDA*),
100 g starch flour,
2 tea spoons baking powder, and
vanilla.

The cake is baked at 200°C in a mould of black sheet lined with greaseproof paper, laced on the lowest level rack provided. The baking time is noted. The cake is cooled on a rack and its crust and texture are examined.